

Work Order ID 70298

Thursday, June 02, 2011 1:50:00 PM



Page 1

Item ID: D3257-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Fitting

Start Date: 6/8/2011 Start Qty: 16.00



Required Date: 6/17/2011 Req'd Qty: 16.00



Reference:

110606

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

Draw Nbr:
D3257Revision Nbr:
Rev A1

100



BAND SAW

Bandsaw

Jaspa Bandsaw

Memo

Cut blank: 0.500" x 0.500" x 1.180" long Bar

110



HAAS CNC VERTICAL MACHINING #1

HAAS 1

HAAS CNC vertical machine #1

Memo

Machine as per Folio FA420 and Dwg D3257-1-Deburr-2-
*****FINISH TAPPING PARTS BY HAND AS PER DWG
D3257*****

120



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

0.00

B-A 11/07/19

16. Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70298

Thursday, June 02, 2011 1:50:00 PM



Page 2

Item ID: D3257-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Fitting

Start Date: 6/8/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

SL 1101-20

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

16

140



Packaging

Packaging

Identify as per dwg & Stock Location: C44

0.00

Memo

0.00

PC441120(16)

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W17/20 JJ
MF 11-07-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 02, 2011 1:49:57 PM

Page 1

Work Order ID: 70298



Parent Item: D3257-1



Parent Item Name: Fitting

Start Date: 6/8/2011

Required Date: 6/17/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP: A|04.04.14|New issue|KJ/RFI|

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B0.500X0.500		Purchased		No		100	f	10.6000	0.1092	1.839158			

AISI 303 Bar .500 x .500



Location	Loc Qty	Loc Code
MAT050	10.6	
✓111571	10.6	

1.8391 f+ 11/07/19
A-A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

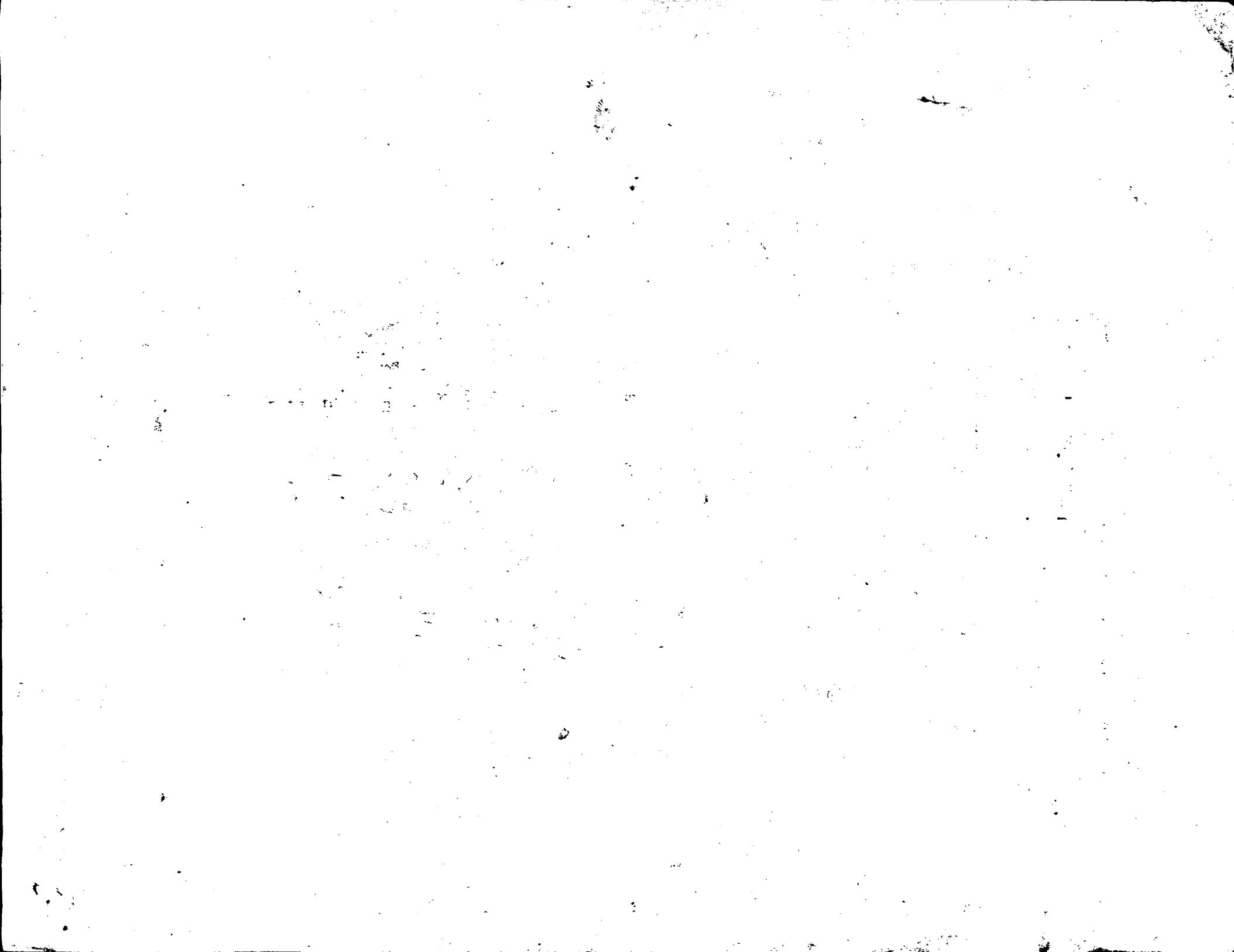
DART AEROSPACE LTD	Work Order:	70798
Description: Fitting	Part Number:	D3257-1
Inspection Dwg: D3257	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>B.A</u>	Audited by:	<u>SL</u>	Prototype Approval:	N/A
Date:	11/07/19	Date:	11-07-20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.06.20	0.455 dimension removed	KJ/JLM	



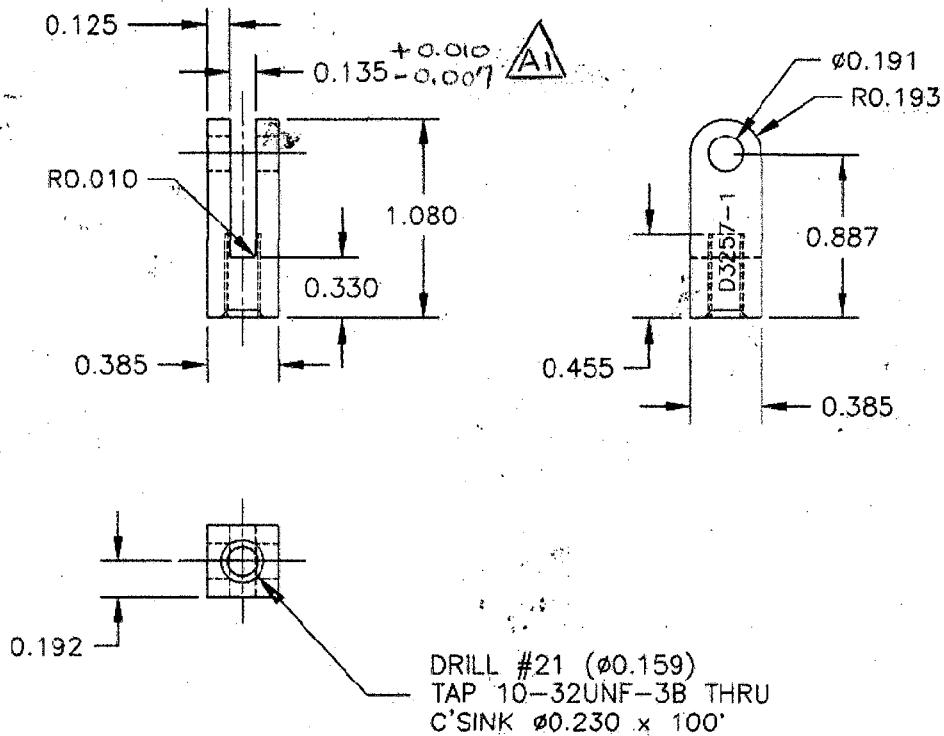


COPY ISSUED

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED W	APPROVED W	DRAWING NO. D3257	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE FITTING	SCALE 1:1
A	04.01.27	NEW ISSUE	
A1	W 04.12.14	ADD TOLERANCE	

RELEASED
04.04.05 ~~W~~

w/0 70298



D3257-1 FITTING

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: AISI 303 SS, BAR (REF DART SPEC. M303B0.500X0.500)
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE DART P/N AS SHOWN

